

BLUE

SPLIT-2

23

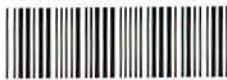
Date: Wednesday, 5/16/2007 8:13:35 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	32378-2	Part Number	D29322UP
Estimate Number	10832	Drawing Number	D2932 REV C
P.O. Number	N/A	Project Number	N/A
This Issue	5/16/2007	Type	MACHINED PARTS
Prsht Rev.	NC	Drawing Revision	C
First Issue	N/A	Material	N/A
Previous Run	31250	Due Date	6/6/2007
Written By		Qty:	12
Checked & Approved By	John 05.16	Um:	Each
Comment	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: B31387	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D2 Date: 07/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 32378

Part Number: D29322

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JK 07/07/04

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Asid etch and Alodine as per QSI 005 4.1

m-f

(12x)
07/07/04

7.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

MLA

8.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



stock unsorted

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST444 PC7/7/5 (12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

R09107/06

Job Completion



W 09.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32378
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.127	0.128	0.127	0.126		
B	0.100	0.140		0.126	0.128	0.128	0.127		
C	0.100	0.140		0.119	0.120	0.119	0.120		
D	0.210	0.230		0.223	0.225	0.224	0.225		
E	1.245	1.255		1.250	1.249	1.249	1.250		
F	1.245	1.255		1.250	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.516		
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.239	0.238		
N	0.100	0.140		0.117	0.118	0.118	0.120		
O	0.540	0.560		0.546	0.549	0.548	0.550		
P	0.490	0.510		0.500	0.501	0.503	0.501		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.492	2.492	2.493		
S	0.240	0.270		0.253	0.254	0.254	0.254		
T	0.100	0.180		0.138	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.367	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.136	1.135	1.139		
Y	1.565	1.585		1.574	1.574	1.575	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JNL</i>
Date:	07/06/29

Audited by:	<i>JL</i>
Date:	07/06/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JL</i>

DART AEROSPACE LTD	Work Order:	32378
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.127	0.129	0.127	0.128		
B	0.100	0.140		0.127	0.128	0.127	0.126		
C	0.100	0.140		0.120	0.120	0.120	0.118		
D	0.210	0.230		0.225	0.224	0.224	0.225		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.516	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.238	0.239		
N	0.100	0.140		0.120	0.118	0.119	0.118		
O	0.540	0.560		0.548	0.548	0.548	0.550		
P	0.490	0.510		0.501	0.502	0.502	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.493	2.493	2.493		
S	0.240	0.270		0.254	0.254	0.254	0.254		
T	0.100	0.180		0.140	0.141	0.138	0.139		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.134	1.134	1.135		
Y	1.565	1.585		1.576	1.573	1.574	1.575		
Z	0.178	0.198		0.188	0.185	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>DMR</i>	Audited by:	<i>JL</i>
Date:	<i>07/06/03</i>	Date:	<i>07/07/03</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JL</i>	<i>JL</i>

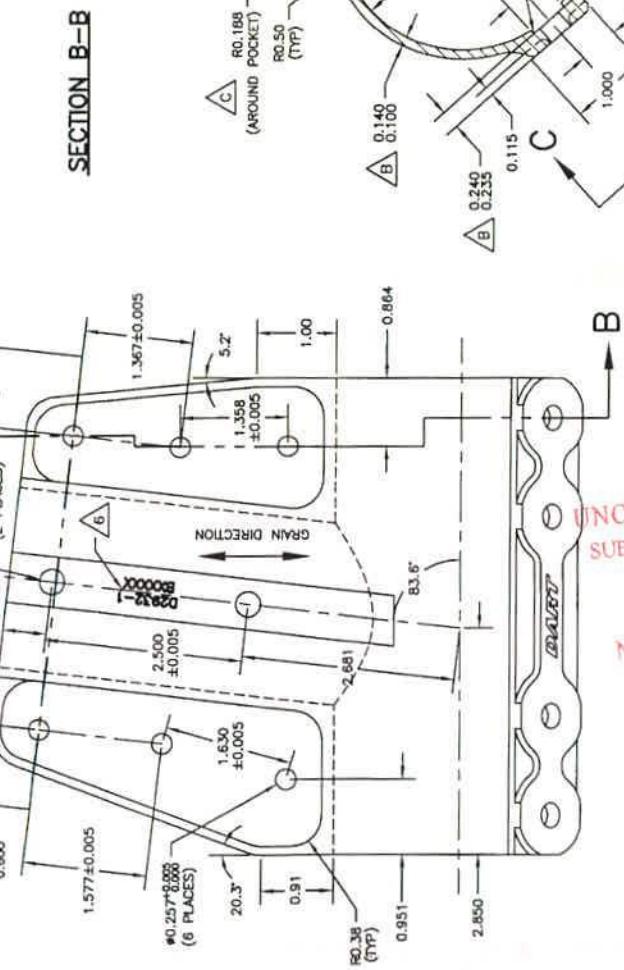
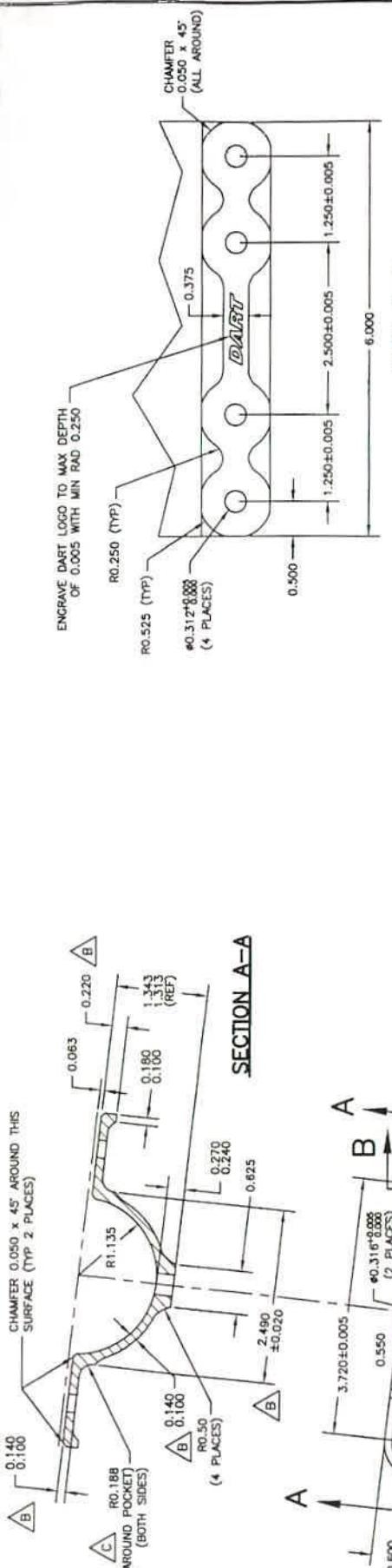
DART AEROSPACE LTD	Work Order:	32378
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.127	0.128	0.128		
B	0.100	0.140		0.127	0.127	0.126	0.125		
C	0.100	0.140		0.119	0.118	0.118	0.119		
D	0.210	0.230		0.225	0.225	0.225	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.498	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.119	0.118	0.119	0.118		
O	0.540	0.560		0.550	0.549	0.550	0.548		
P	0.490	0.510		0.502	0.502	0.501	0.502		
Q	3.715	3.725		3.717	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.493	2.493	2.494		
S	0.240	0.270		0.254	0.254	0.254	0.254		
T	0.100	0.180		0.140	0.141	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.135	1.136	1.135		
Y	1.565	1.585		1.575	1.571	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JML</i>	Audited by:	<i>JF</i>
Date:	07/06/130	Date:	07/07/130

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JF</i>	<i>JF</i>



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NO. 32378

533

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

6

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (Q9-A-250/12)
(MAKE FROM D6101-003 SADDLE BILL, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) POWDER COAT GLOSS WHITE (REF 4.3-5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED.
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ENGRAVE PART AND BATCH NUMBER IN THIS AREA IF 0.010 TO 0.016 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25		
B	00.05.29	CHANGED GEOMETRY AND MATERIAL		
A	99.10.29	NEW ISSUE		
DESIGN		DART DRAWN BY CB	DART AEROSPACE USA, INC. RELLINGEN, NC	REV. C
CHECKED		APPROVED 	DRAWING NO. D2932	SHEET 1 OF 1
DATE	05.11.09			SCALE
				FAIRFAX, OUTDOOR

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DESIGN	DRAWN BY <i>C.B.</i>	CHECKED	DART
APPROVED	DRAWING NO. <i>S-1</i>	APPROVED	D2932
DATE	TITLE	DATE	SCALE
06-11-68	S-1	06-11-68	1:1

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